



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4276-1

Job Sheet 174740



Part No: D4276-1

Job Qty: 10 ea **3**

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 3/23/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 10 Ea		3/22/18	0.00	0.00	Start Up Machining-2		18/03/18
100	Bandsaw	10 pcs		3/22/18	0.00	0.16	Bandsaw1		DAS 18/03/18
110	CNC Vertical Machining	10 pcs		3/22/18	0.58	17.86	HAAS1-4		52 18/03/18
120	QC	10 pcs		3/22/18	0.00	0.00	QC2 Machining-2		9-89 18/03/18
130	QC	10 pcs		3/22/18	0.00	0.00	QC8 Machining-2		18/03/18
140	HandFinish	10 pcs		3/22/18	0.00	1.18	HandFinish1		18-03-28
145	Powdercoat	10 pcs		3/23/18	0.00	0.90	Powdercoat1		18-03-28
150	QC	10 pcs		3/23/18	0.00	0.00	QC3		38 DAS
180	Packaging	10 pcs		3/23/18	0.00	0.00	Packaging3-2	51463	MAR 28 2018
190	QC21-SA	10 Ea		3/23/18	0.00	0.00	QC21		9-89

Part Op 100 - Cut Blank to 36.630"

Descriptions: 110 - 1-Machine per folio FB007

145 - MASK AS PER DWG

M188700 START 11:30 CUT:3200 FINISH - 12:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X06.000	6061T6 Bar 1.00 X 6.00	30.5200 ft (3.052 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X06.000	31	68	0

Part Specifications

Specifications could not be found.

Plex 3/21/18 R:16 AM dart.lacelle.linda

2 X 5042202
6.105
1 X 5033407
3.053

2 X 5015872
5033407

5055678
5055679



Container No: S055680



Part: D4276-1

Job No: 174740

Serial No/Batch: S055680

Revision:

Inspector:

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Date: 03/27/18

DART AEROSPACE LTD		Work Order: 174740
Description: Aft Beam		Part Number: D4276-1
Inspection Dwg: D4276	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.750				
20.500	+/-0.010	20.500				
Ø0.381	+0.000/-0.001	0.380				
14.380	+/-0.010	14.381				
R0.75	+/-0.030	R.0.75				
3.50	+/-0.030	3.503				
16.38	+/-0.030	16.38				
5.00	+/-0.030	5.00				
0.75	+/-0.030	0.751				
2.75	+/-0.030	2.75				
3.00	+/-0.030	3.004				
1.250	+/-0.010	1.249				
4.50	+/-0.030	4.50				
0.734	+/-0.010	0.735				
0.108	+/-0.010	0.108				
36.38	+/-0.030	36.38				
0.95	+/-0.030	0.952				
0.60	+/-0.030	0.602				
2.70	+/-0.030	2.695				
1.10	+/-0.030	1.101				
1.25	+/-0.030	1.252				
0.75	+/-0.030	0.749				
3.000	+/-0.010	2.998				
1.500	+/-0.010	1.499				
Ø0.191	+0.005/-0.001	0.191				
2.300	+/-0.010	2.299				
3.50	+/-0.030	3.499				
R0.60	+/-0.030	R.0.60				
1.70	+/-0.030	1.698				
0.65	+/-0.030	0.651				

Measured by: DAS 52	Audited by: B.A	Preliminary Approval:
Date: 18/03/27	Date: 18-03-28	Date:

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	